

Work Order ID 50195

July 10, 2009 11:21:41 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/27/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

I- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221□□2-
remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per
dwg D2221□□3- tack weld mesh on basket as per dwg D2221□□ A/R ER316
S.S. Rod Batch: 4109213

8/09/07/21

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

6/09-07-21

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

27 506421

(40) 6

Work Order ID 50195

July 10, 2009 11:21:41 AM

Page 2

Item ID: D2221

Accept

Setup Start

Revision ID: H

Stop

Item Name: 350 Basket Base

Start Date: 7/15/09 Start Qty: 1.00

Cust Item ID:

Required Date: 7/27/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

Powdercoat

Powder Coating

1- Plug holes prior to

2- 1ST COAT: START

TIME:

10:30

OVEN TEMPERATURE:

1000°

FINISH TIME:

11:21:48

09-07-22

11:00

***** 2nd coat if

necessary

2ND COAT: START

START 11:30 TEMP 400° FINISH 12:00

PRESS WASH 09-07-22

140

QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

150

QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

u 07.07.28

Picklist Print

Page 1

July 10, 2009 11:21:41 AM

Work Order ID: 50195

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base



Comments:

Start Date: 7/15/09

Required Date: 7/27/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH		Manufactured	No			100	Each	13.0000	1.0000			
												
Rib												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 13

48101 1

48318 4

48427 8

1x

SY 09/07/16

D2221-5RevH		Manufactured	No			100	Each	2.0000	2.0000			
												
Rib												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 2

48390 2

2x

SY 09/07/16

D2221-7RevH		Manufactured	No			100	Each	5.0000	1.0000			
												
Rib												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 5

48201 1

48450 4

1x

SY 09/07/16

Picklist Print

July 10, 2009 11:21:41 AM

Work Order ID: 50195

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Comments:

Start Date: 7/15/09


Required Date: 7/27/09

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			100	Each	13.0000	2.0000			
												
Basket Hinge												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	13	
47263	1	
48443	12	

D2235-1RevB1		Manufactured	No			100	Each	15.0000	2.0000			
												
Basket Rib												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	15	
48665	5	
50029	10	

D2581RevA1		Manufactured	No			100	Each	33.0000	2.0000			
												
Mounting Bracket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	33	
46086	2	
48428	31	

2x SY 09/07/16

2x SY 09/07/16

2x SY 09/07/16

Picklist Print

July 10, 2009 11:21:41 AM

Work Order ID: 50195



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 7/15/09

Required Date: 7/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3442-1RevA		Manufactured	No			100	Each	20.0000	2.0000			
Shim												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	20	
46767	1	
47074	7	
50023	12	

2x *SY 09/07/16*

D3825-041RevA		Manufactured	No			100	Each	6.0000	2.0000			
Rib Assembly (Basket End)												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
48668	6	

2x *SY 09/07/16*

D3826-041RevB		Manufactured	No			100	Each	2.0000	2.0000			
Rib / Gusset Assembly												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
48644	2	

B50028 2x

SY 09/07/16

July 10, 2009 11:21:41 AM

Shop Packet Print

Picklist Print

July 10, 2009 11:21:41 AM

Work Order ID: 50195

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Comments:

Start Date: 7/15/09

Required Date: 7/27/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3827-041RevA		Manufactured	No			100	Each	6.0000	1.0000			
												
Rib Assembly (Inboard)												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

48454

6

D3832-1RevA

Manufactured

No

100

Each

5.0000

1.0000



Mesh (Base)



1x

SY 09/07/16

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

46306

1

46774

1

Main Warehouse

WA

3

48645

3

1x

SY 09/07/20

Picklist Print

July 10, 2009 11:21:41 AM

Work Order ID: 50195

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Comments:

Start Date: 7/15/09

Required Date: 7/27/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3833-1RevA		Manufactured	No			100	Each	5.0000	2.0000			



Mesh (Base End Face)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

5

46665

1

48646

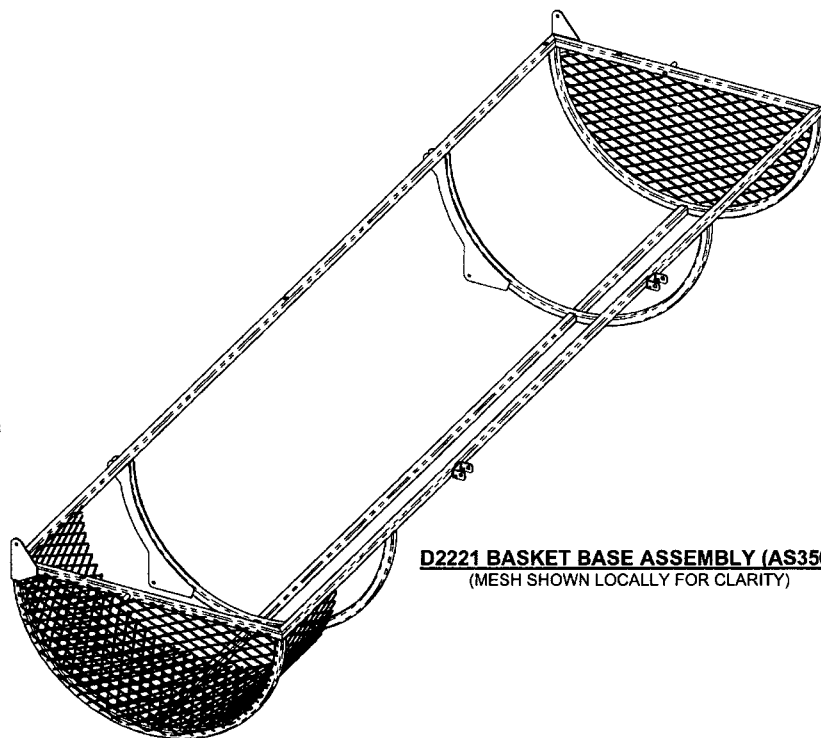
4

50025

1x

1x

SY 09/07/21



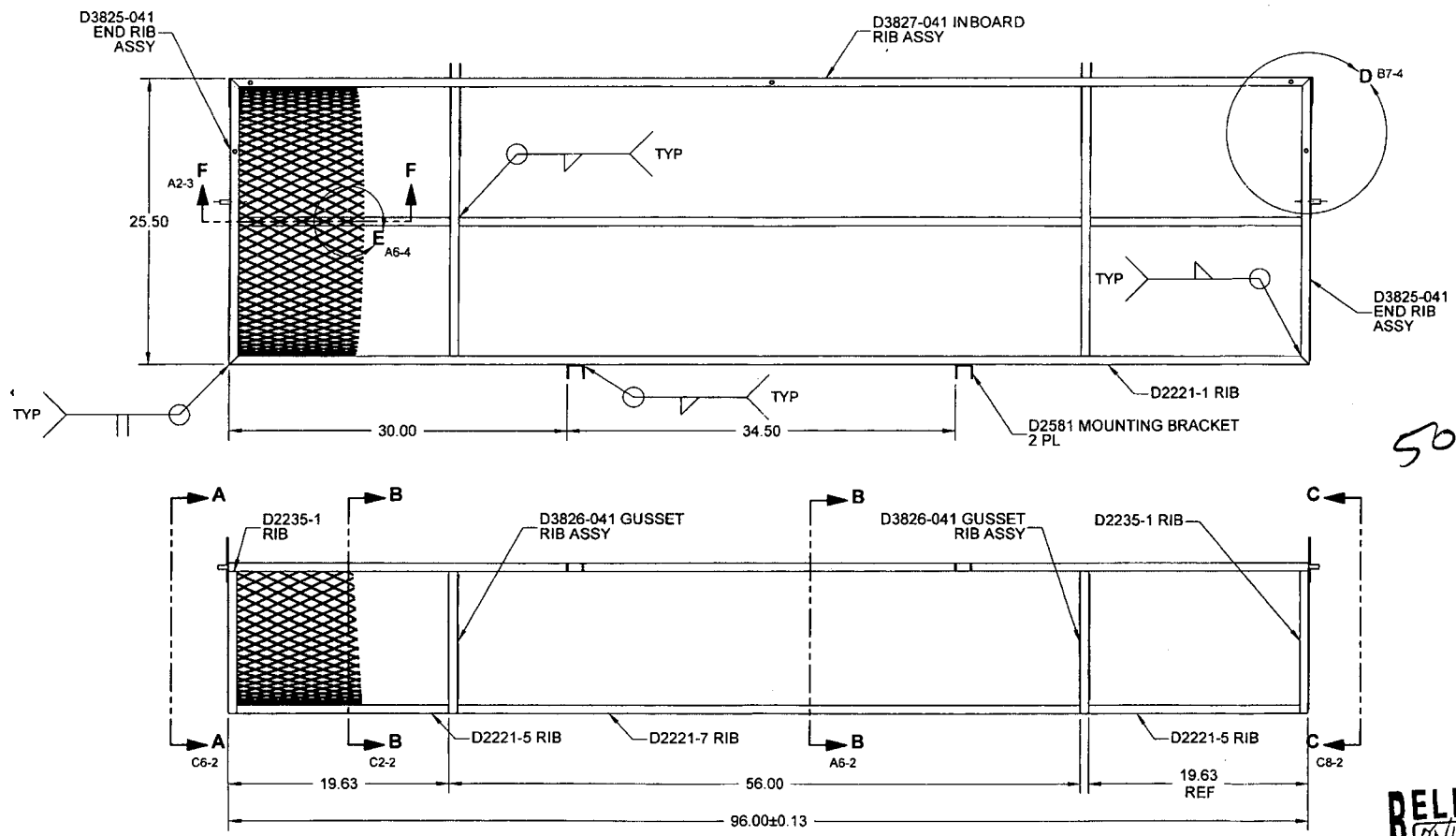
D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

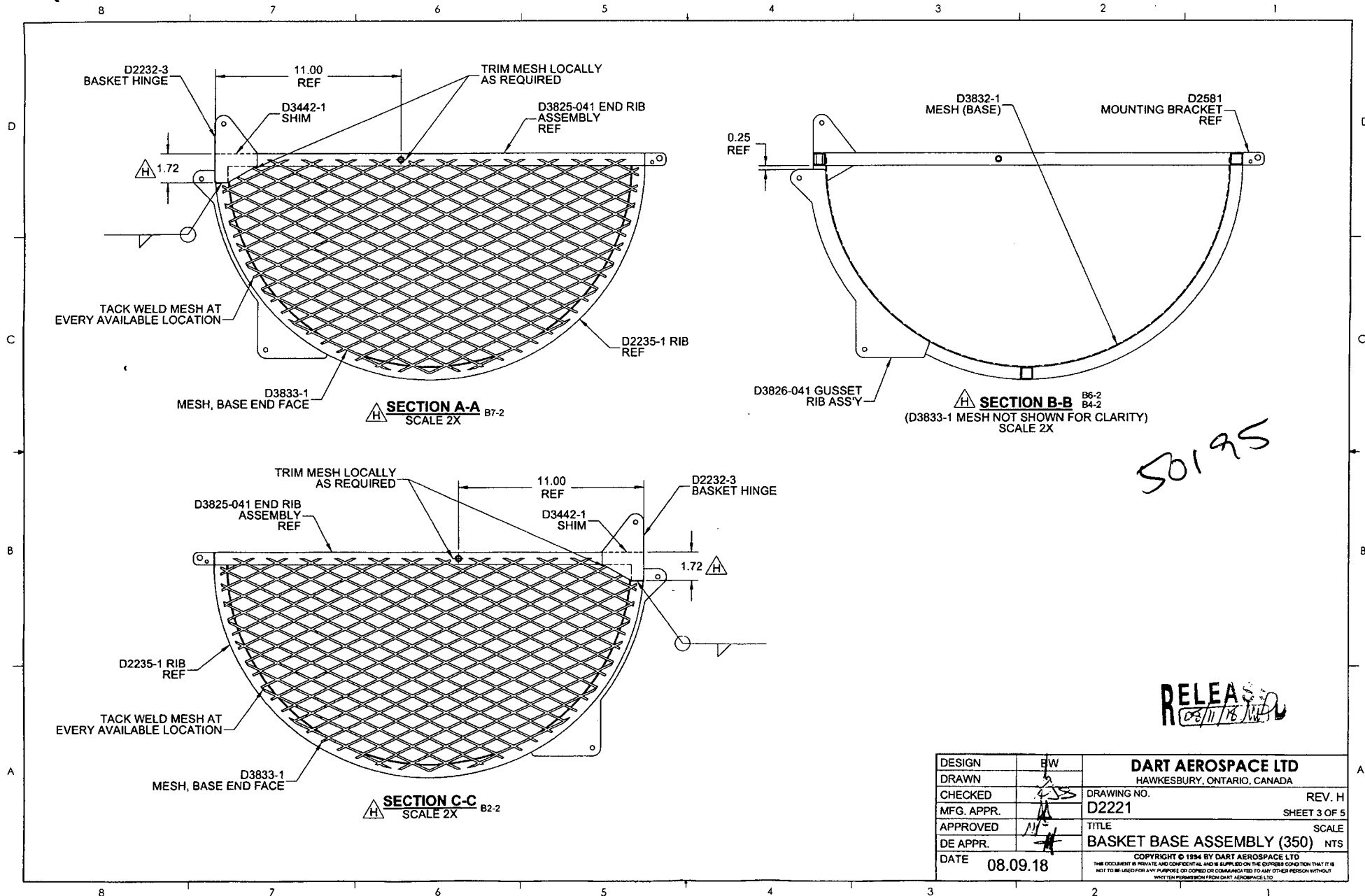
H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C8-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

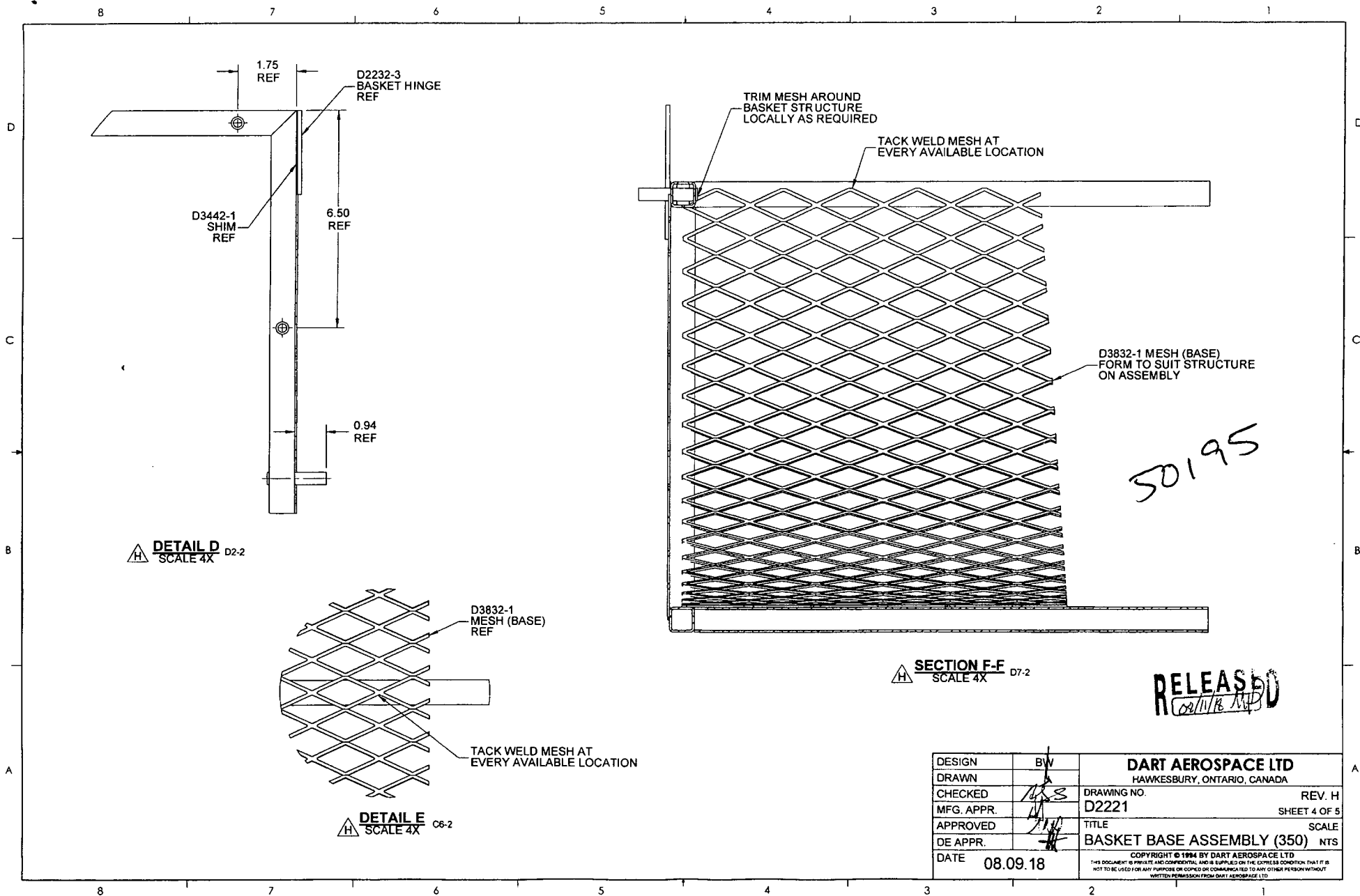


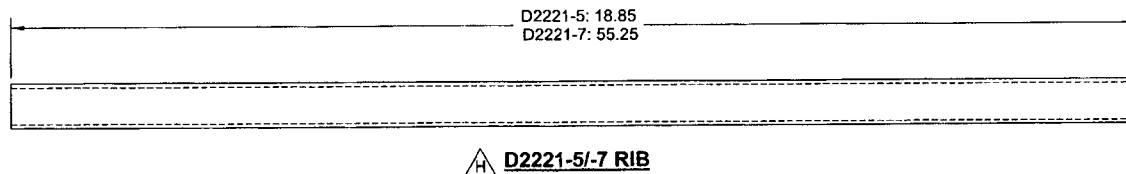
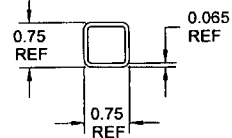
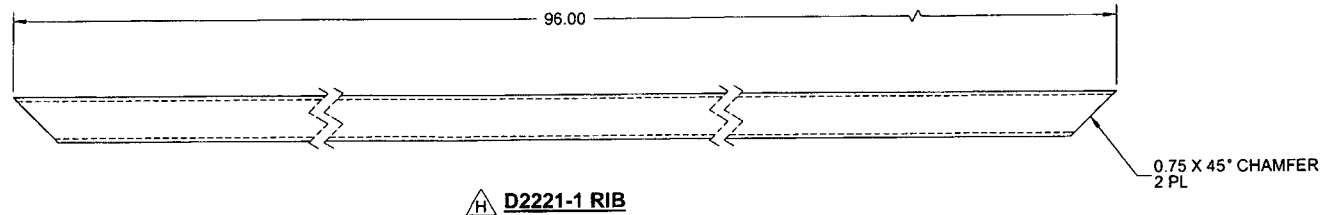
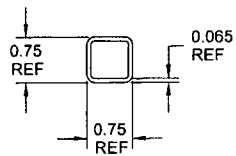
D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	ADS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ADS	DRAWING NO.	REV. H
MFG. APPR.	ADS	D2221	SHEET 5 OF 5
APPROVED	ADS	TITLE	SCALE
DE APPR.	ADS	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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50195

RELEASED
08/11/18 W